**Work Order ID 76540** *76540*

*November-16-11 1:38:30 PM*

| | | | |
|---|---|---|---|
| **Item ID:** | D4017-9 | **Accept** | *N900040100* |
| **Revision ID:** | | **Setup Start** | *NS1* |
| **Item Name:** | Rib | **Stop** | *NS2* |
| **Start Date:** | 16/11/2011 | **Start Qty:** 6.00 | *6* 8 Cpl |
| **Required Date:** | 22/11/2011 | **Req'd Qty:** 6.00 | *6* |
| **Cust Item ID:** | | **Customer:** | |
| **Reference:** | | | |

**Run Start** *NR1* **Stop** *NR2*

**Approvals:** **Process Plan:** HLJ **Date:** 11\11\16 **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D4017 | C |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|
| 100<br>*100*<br>Large Fab<br>Large Fab | **Memo**<br>1- Cut tube as per dwg D4017<br>2- Deburr and remove identify marks | 0.00<br>0.00<br>Ae 12.01.03 | | | | |
| 110<br>*110*<br>QC<br>Quality Control | QC6- Inspect dimensions to drawing<br>**Memo** | 0.00<br>0.00<br>Lpc # 12.01.04 | | | | |
| 120<br>*120*<br>Packaging<br>Packaging | Identify as per dwg & Stock Location:_______<br>**Memo** | 0.00<br>0.00<br>Ae 12.01.03 | 8 | Ø | | |

WA - BASKET CELL

**Work Order ID 76540**
*November-16-11 1:38:30 PM*

*76540*

**Item ID:** D4017-9
**Revision ID:**
**Item Name:** Rib

**Accept** *N900040100*

**Setup** **Start** *NS1*
**Stop** *NS2*

**Start Date:** 16/11/2011 **Start Qty:** 6.00 *6*
**Required Date:** 22/11/2011 **Req'd Qty:** 6.00 *6*
**Reference:**

**Cust Item ID:**
**Customer:**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

**Run** **Start** *NR1*
**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 *130* | QC21- Final Inspection - Work Order Release | 0.00 | | | | CK 12/01/06. | | | |
| QC Quality Control | **Memo** | 0.00 | | | | | | | |

12-01-5 (8)

# Picklist Print

*November-16-11 1:38:35 PM*

**Work Order ID:** 76540

**Parent Item:** D4017-9

**Parent Item Name:** Rib

**Start Date:** 16/11/2011 **Required Date:** 22/11/2011

**Start Qty:** 6.00 **Required Qty:** 6.00

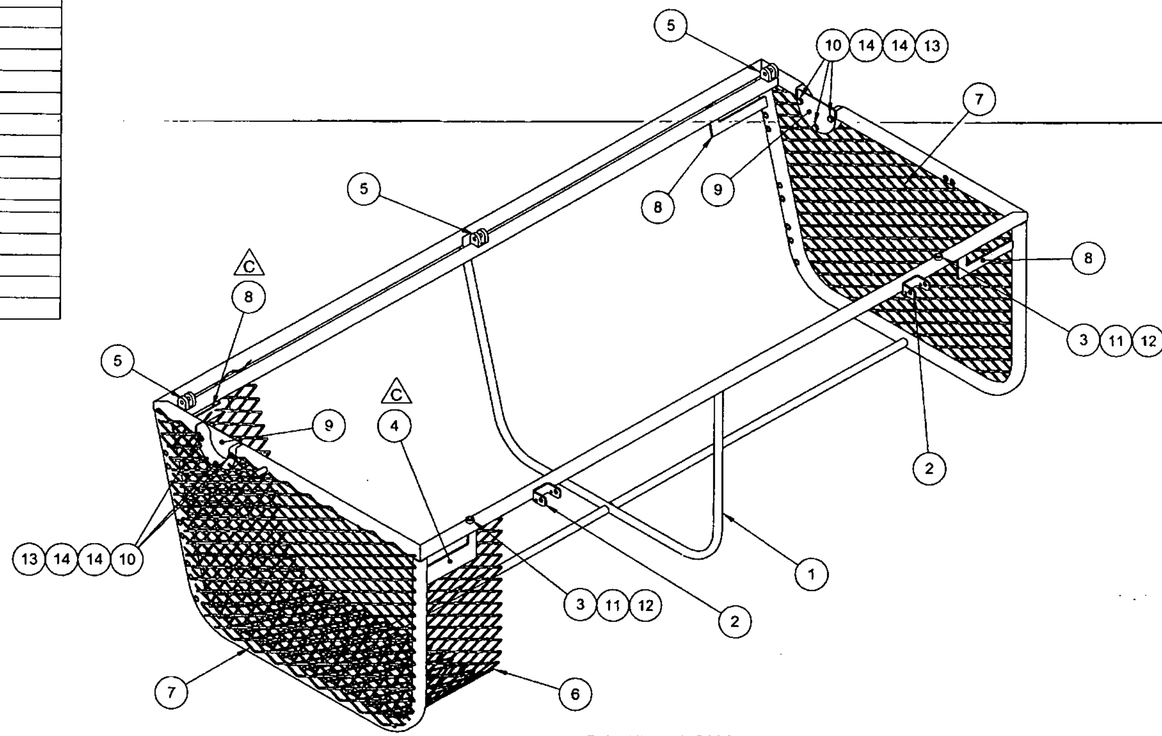
**Comments:** IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.17 chg qc5 to 6 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304TS0.500W.049 Square Tubing | | Purchased | No | | | 100 | f | 667.9122 | 2.28166 | 14.41048 | 19.2139 | 12-01-03 | |

**

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT034 | 667.9121658 | | |
| 116610 | 0.8383 | | |
| 117721 | 0.3234 | | |
| 117999 | 82.7504658 | | 19.2139 |
| 118460 | 584 | | |

| ITEM | QTY -041 | P/N | DESCRIPTION |
|---|---|---|---|
| | X | D4017-041 | **SHORT BASKET BASE ASSY (350)** |
| 1 | 1 | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 2 | D2931 | BUMPER |
| 4 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-3 | MESH (350 BASKET SHORT BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN960JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |




**D4017-041 SHORT BASKET BASE ASSY (350)**
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76540 M.L.J
11/11/16

ECN 10-596
RELEASED
10.08.12

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 28.8 lbs APPROX
8) INSTALL AFTER FINISH
9) MASK HOLES PRIOR TO POWDER COAT
10) WELD PER DART QSI 004

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| C | ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES. | MB | 10.07.23 |
| B | QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3) | JPH | 10.03.25 |
| A | NEW ISSUE | AJS | 10.03.04 |

| | | |
|---|---|---|
| DESIGN | AJS | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D4017 — REV. C — SHEET 1 OF 5 |
| MFG. APPR. | J.F.S. | |
| APPROVED | | TITLE: SHORT BASKET BASE ASSY (350) — SCALE: NTS |
| DE APPR. | | |
| DATE | 10.07.23 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

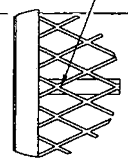
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

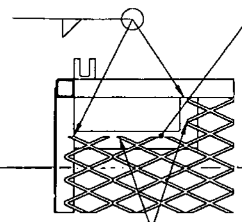
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | | Corrective Action Section B | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

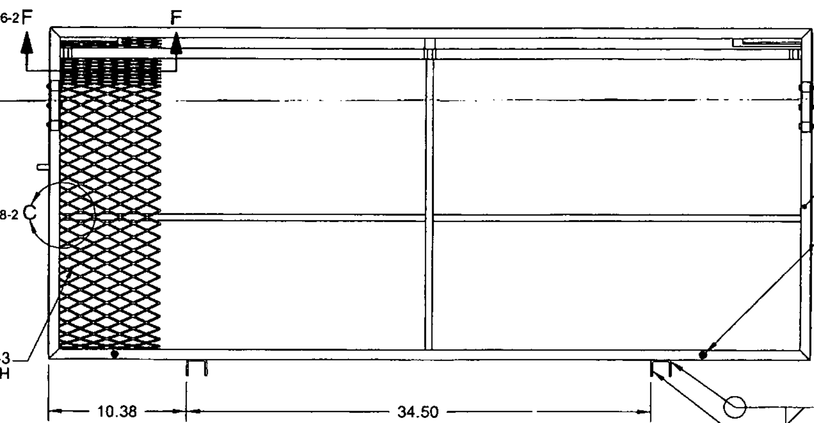
76540

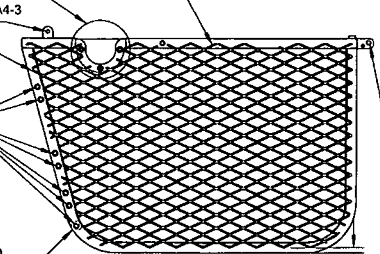


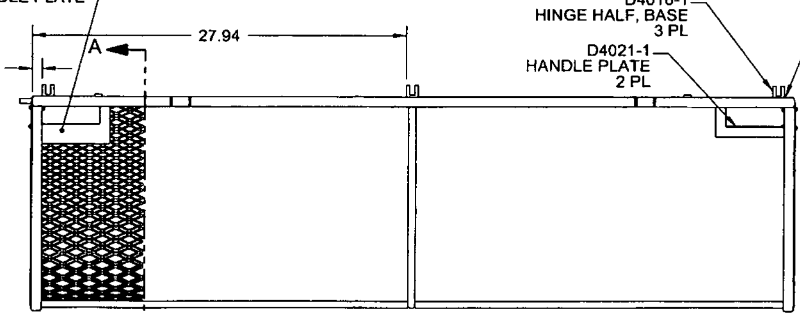

**DETAIL C** D5-2




**SECTION F-F** D5-2
TYPICAL FOR ALL
HANDLE PLATES




**D4017-041 SHORT BASKET BASE ASSY (350)**
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED 10.08.12

| | |
|---|---|
| DESIGN | AJS |
| DRAWN | |
| CHECKED | |
| MFG. APPR. | JFS |
| APPROVED | |
| DE APPR. | |
| DATE | 10.07.23 |

**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4017 REV. C
SHEET 2 OF 5
TITLE SHORT BASKET BASE ASSY (350) SCALE NTS

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

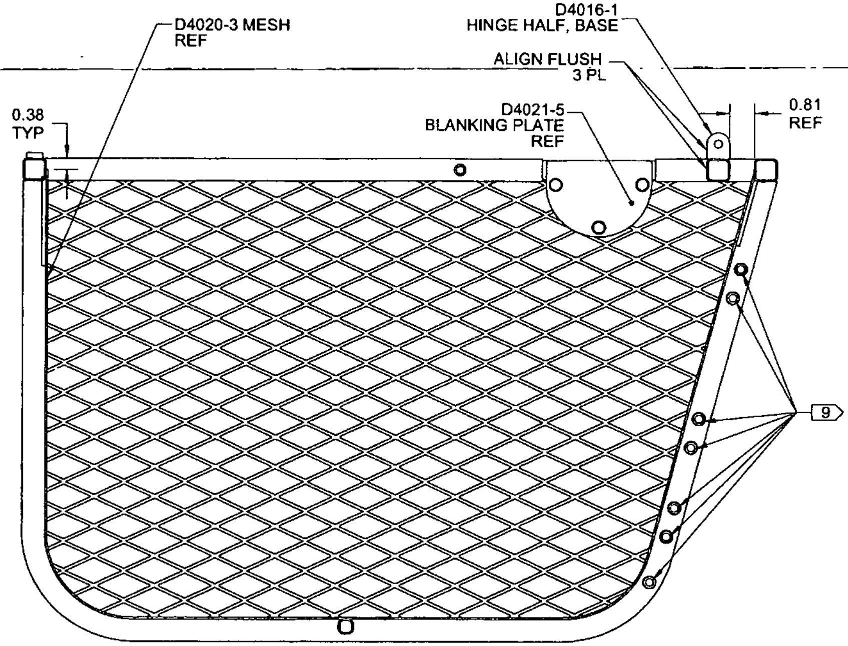
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

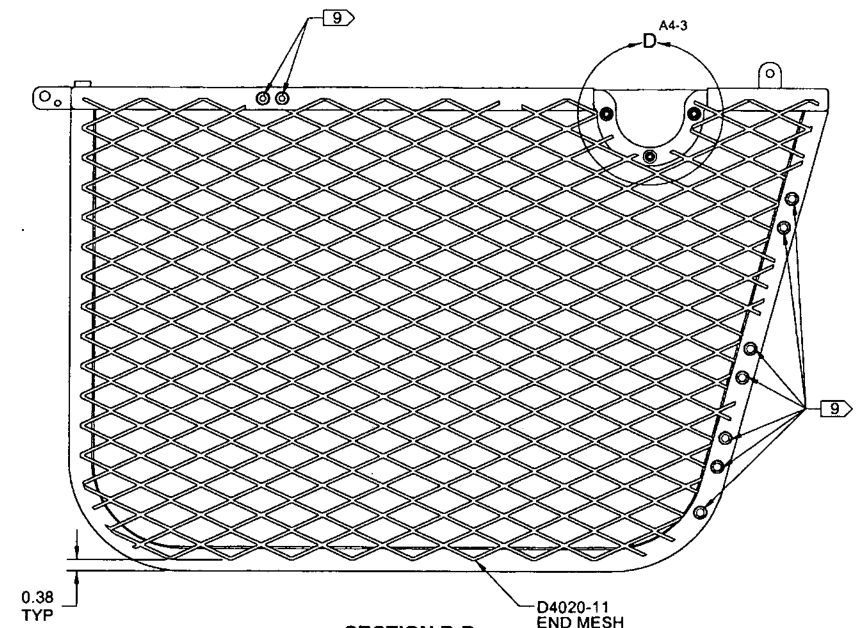
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

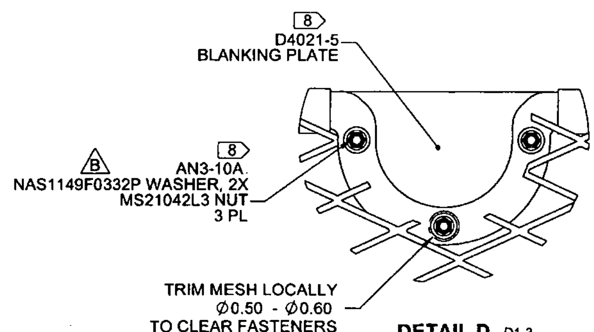
76540




**SECTION A-A** A5-2




**SECTION B-B** A2-2




**DETAIL D** D1-3 B8-2

RELEASED 10.08.12

| DESIGN | ASS | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | | |
| CHECKED | | DRAWING NO. D4017 — REV. C — SHEET 3 OF 5 |
| MFG. APPR. | J.F.S. | |
| APPROVED | | TITLE: SHORT-BASKET-BASE ASSY (350) — SCALE: NTS |
| DE APPR. | | |
| DATE | 10.07.23 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

**Resolution:** ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

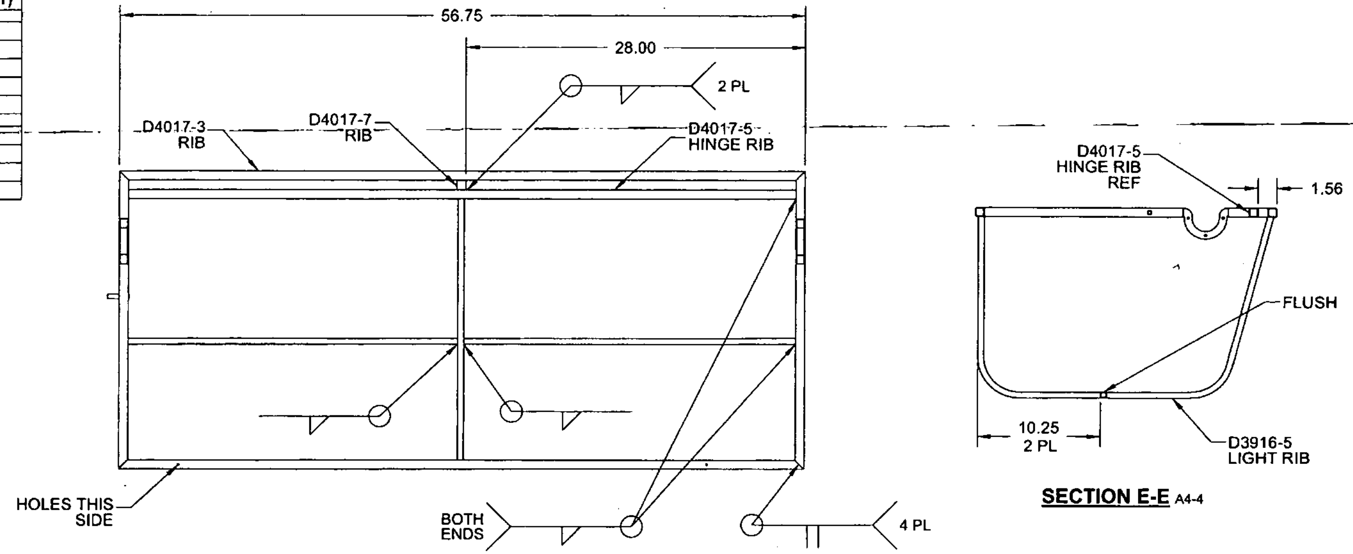
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

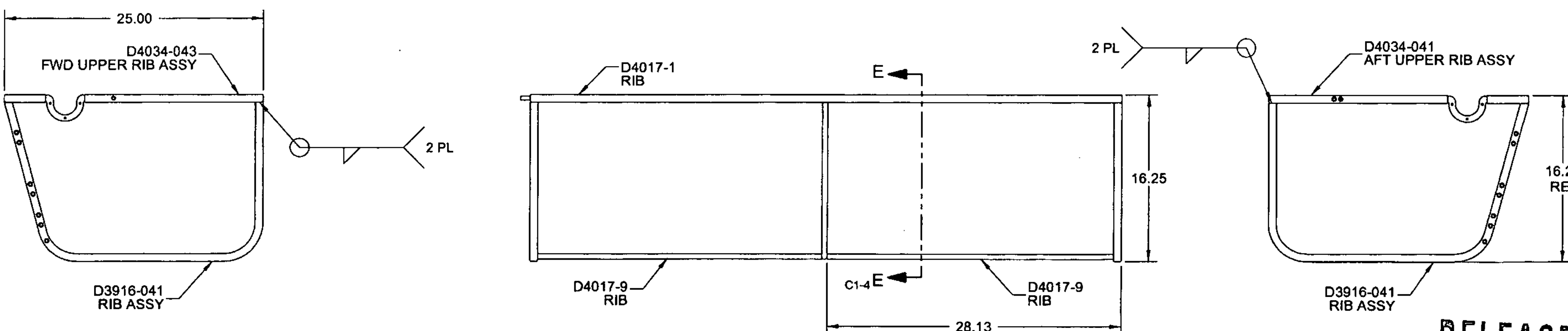
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

76540

| ITEM | QTY -101 | P/N | DESCRIPTION |
|---|---|---|---|
| | X | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 1 | 1 | D4017-1 | RIB |
| 2 | 1 | D4017-3 | RIB |
| 3 | 1 | D4017-5 | HINGE RIB |
| 4 | 1 | D4017-7 | RIB |
| 5 | 2 | D4017-9 | RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D3916-5 | LIGHT RIB |
| 8 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 9 | 1 | D4034-043 | FWD UPPER RIB ASSY |




**SECTION E-E** A4-4




8 **D4017-101 TUBULAR ASSY (350 SHORT BASKET)**

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 15.26 lbs
8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4017-101
9) WELD PER DART QSI 004

RELEASED 10.08.12

| | | |
|---|---|---|
| DESIGN | ASS | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D4017 — REV. C — SHEET 4 OF 5 |
| MFG. APPR. | STS for J.L.M | |
| APPROVED | JM | TITLE SHORT BASKET BASE ASSY (350) — SCALE NTS |
| DE APPR. | | |
| DATE | 10.07.23 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

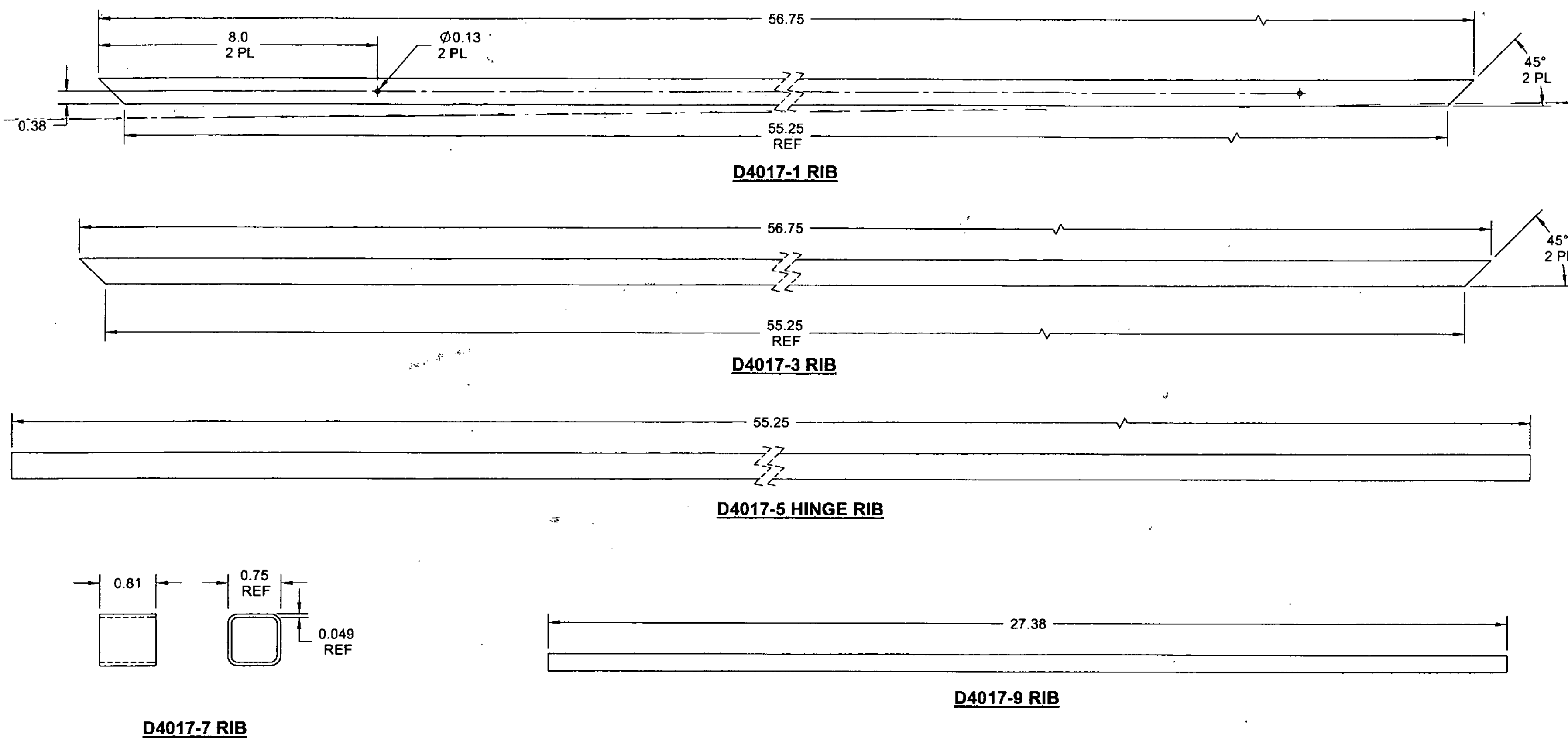
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

76540




RELEASED 10.08.12

NOTES:
1) MATERIAL -1 THRU -7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

| | | |
|---|---|---|
| DESIGN | AJS | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D4017 — REV. C — SHEET 5 OF 5 |
| MFG. APPR. | J.F.S. | |
| APPROVED | | TITLE: SHORT BASKET BASE ASSY (350) — SCALE: NTS |
| DE APPR. | | |
| DATE | 10.07.23 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

**Resolution:** ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | | Corrective Action Section B | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries